

In the specification:

Kindly amend the text at page 4, from line 14, as follows:

731
In contrast, a pouch made according to the present invention starts with a flexible material in which the sealant is provided at half the final thickness, i.e. 45 microns. The material is then punched and the entire sealant side is then supplemented with a further 45 microns worth of molten sealant which is applied by extrusion coating, completing the final thickness of the inner sealant layer, while simultaneously functioning as the equivalent of an integral closure sheeting pouch. The final product has a sealant layer of about 80-90 microns in thickness, except possibly for the area of the occluded punched hole. Even if the punched hole is completely filled with the molten sealant, which factor can be easily controlled by one skilled in art by varying such conditions as extrusion rates and cooling rates, it still would provide an area of weakness in the wall of the bag which can be pierced by a child with a pointy straw.

Kindly amend the text at page 7, from line 11, as follows:

732
FIG. 3 shows a perspective view of a beverage bag to be produced (extrusion coating);

Kindly amend the text at page 7, from line 17, as follows:

733
FIG. 6 shows a section taken along line 6-6 in FIG. 5 and looking in the direction of the arrows;

FIG. 6 7 shows a perspective view of a beverage bag to be produced + , according to the laser embodiment; and

123
~~FIG. 7 shows a section taken along line 2-2 in FIG. 5 and looking in the direction of the arrows, and~~

Kindly amend the text at page 8, from line 3 as follows:

124
FIG. 1 shows, in a schematic ~~representations~~ representation, an apparatus for producing a beverage container in accordance with the present invention as further illustrated in FIGS. 3 and 4. The sheets of flexible web material necessary for making the front side sheeting web 7, rear side sheeting web 8 and bottom sheeting web 15 of a beverage container 50 (FIG. 3) are wound onto a front side sheeting supply roll 1 of flexible web material, a bottom sheeting supply roll 4 of flexible web material and a rear side sheeting supply roll 2 of flexible web material. With the aid of conveying rollers 3, the individual sheeting webs dispensed from rolls 1, 2 and 4 are each pulled from their respective supply rolls in a conveying direction. The hole punching station 5 punches at least one piercing hole 19, or a plurality of piercing holes as shown in another exemplary embodiment, in the front side sheeting web 7.

Kindly amend the text at page 10, from line 1 as follows:

125
FIG. 5 shows a schematic representation of the front side web sheeting of an exemplary embodiment utilizing extrusion lamination. One exemplary embodiment of this method begins with a starting web material 29 which comprises a laminate of structural layer 21 and air/moisture barrier layer 22, in which punch hole 23 27 was previously provided and onto which are applied a molten adherence layer 25 and an outer layer 26. The adherence layer 25 comprises sealant material which is

liquefied and spread or extruded uniformly on to the entire surface of the air/moisture barrier layer 22, and thereby occluding the punch hole 23 27 with a layer of sealant. The outer layer 26, possibly made from polyethylene or some other sealant-type material, is placed onto the adherence layer 25 during the process, using the adherence layer 25 as a an adhesive in order to stick the lamina of the web together. It is also contemplated that some adhesive, other than molten sealant, could be used for the adherence layer 25, i.e. the outer layer 26 and adherence layer 25 need not be from the same material.

Kindly amend the text at page 10, from line 19, as follows:

In another exemplary embodiment of the invention as shown in FIGS. 7-8, the flexible web material is provided with a weakened point, by use of laser technology as follows. The web 30, intended to be the front side of the bag, passes under a movable laser source 34. The laser beam 35, may be applied using as much as 3 to 4 times the energy used in normal scoring treatment. The laser beam 35 is applied in a pattern of at least two intersecting lines, and is shown in the exemplary embodiment forming a cross-shaped scoring pattern 36 on the structural layer 21 of the front side web sheet 30 of the pouch 40. By adjusting the height of the beam-source, the scored intersection point 37 may be up to 3 to 4 times wider than a score line produced by normal treatment, and thereby more visible and easy to hit with a straw.